

Work Order ID 105681

105681

Page 1

Monday, August 12, 2013 10:55:28 AM

Item ID: D2438

D2438

Accept

N900040100

Setup Start *NS1*

Revision ID:

B105681

Stop *NS2*

Item Name: Clamp

Start Date: 8/12/2013 Start Qty: 120.00

120

Cust Item ID:

Required Date: 9/6/2013 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 13/08/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2438

Rev C

100

0.00

100

Waterjet

FLOW CNC Waterjet

PURCHASING

Memo

0.00

Cut as per dwg D2438

prog rev:

dwg rev:

P10.20895

waterjet / machine as per dwg D2438 REV.C

QC2- Inspect parts off machine FAI/FAIB

0.00

springside Industries

110

110

QC

Quality Control

Memo

0.00

Ensure Material Release Note is attached

rec'd + inspect attached c/c to w10

120

120

QC

Quality Control

QC2 Inspect parts - second check

0.00

Memo

(6.786" center to center)

0.00

27
28
13917

CL 13/08/12 120

13/9/12 (120)

DO
ca

purch.

rec'd.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
--	---	---

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> <input type="checkbox"/>	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 105681

105681

Page 2

Monday, August 12, 2013 10:55:28 AM

Item ID: D2438 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clamp
 Start Date: 8/12/2013 Start Qty: 120.00 *120* Cust Item ID:
 Required Date: 9/6/2013 Req'd Qty: 120.00 *120* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00				107			PTO 8/16/13
Small Fab	Memo 1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg usind DT9709	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				107			
Quality Control	Memo	0.00							
150 *150* Packaging	Identify as per dwg & Stock Location: 51456	0.00				107X			13-09-20
Packaging	Memo	0.00							

NCR: ☒ Yes ☐ No

PINK
13-3134

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: twf Date: 13/10/22

QA Closed: twf Date: 13/10/22

Work Order: <u>165481</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D 2438</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-3072</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input checked="" type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input checked="" type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									
	<u>13/09/19</u>	<u>130</u>	<u>13</u>	Found at Bendig that Qty x 13 are parts have slag on them from being laser cut. The marking/cuts we missed at inspection. Re. 10A & way press cutting by supply.	DAS 16 9-89 052042 13/09/19	SCRAP + Destroy Qty x 13 No Replz. Contact supplier for issn of slag on parts Attach copy of E-mail to wlo.	Ae 13-0008 M. J. \$5.72 ea.	DAS 27 9-89 139.20	DAS 16 9-89 052042 13/09/19

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other <u>was missed @ inspection +</u> <u>supplier issue</u>	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled
---	---	---	--	---

Work Order ID 105681***105681***

Page 3

Monday, August 12, 2013 10:55:28 AM

Item ID: D2438

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp

Start Date: 8/12/2013 Start Qty: 120.00

120

Cust Item ID:

Required Date: 9/6/2013 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

Handwritten signature and date: 13-09-24

Handwritten date: 13-09-24

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

Monday, August 12, 2013 10:55:27 AM

Page 1

Work Order ID: 105681

Parent Item: D2438

Parent Item Name: Clamp

Start Date: 8/12/2013

Required Date: 9/6/2013

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	286.3522	0.04	5.0526316			

Location	Loc Qty	Loc Code
MAT020	286.3521686	
122245	0.1713688	
123136	140.8	
124428	23.61	
125599	5.410631	
M126159	116.360169	

08/13/08/12.

N/A.

D2438B

X 120

8/13/13 (120)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

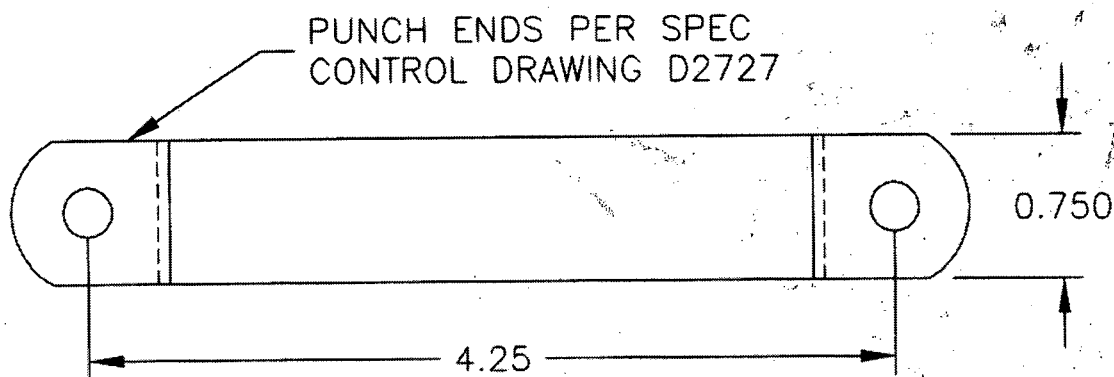
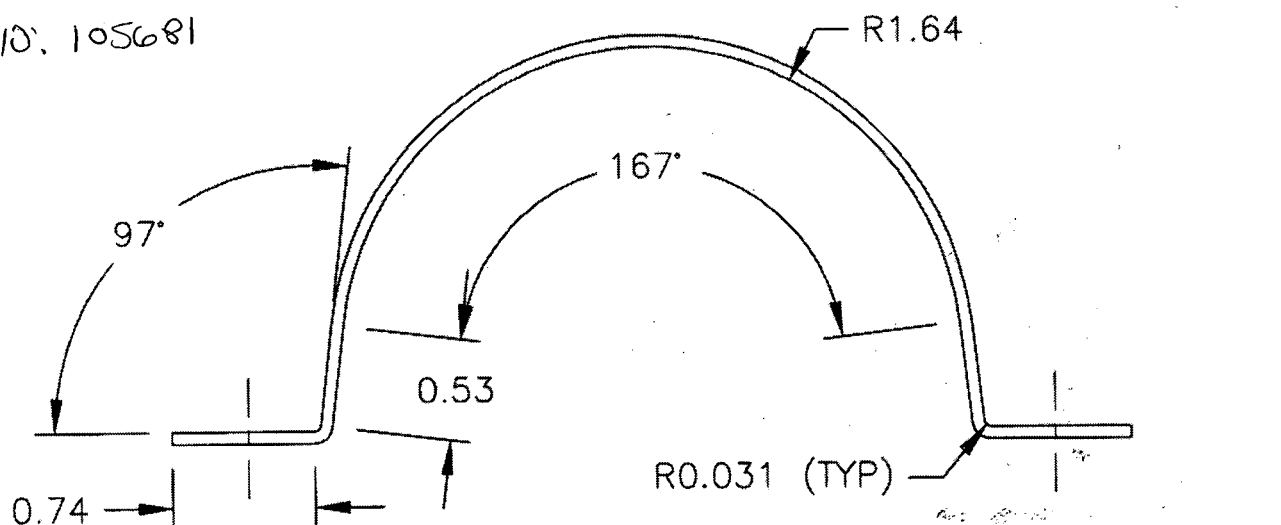
Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>CS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE

CL 13/68112
W/D: 105681



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK
MINIMUM REQUIREMENT IS ANNEALED CONDITION

00 06.06
CP 00 06.07

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Michael Gregoire

From: Matthew Challice <matt@springsideindustries.com>
Sent: September 19, 2013 2:21 PM
To: Michael Gregoire
Subject: RE: PO20895

Good Afternoon

Sorry I missed your call, been a crazy day today...

I originally quoted all of the thin gauge materials to be laser cut, does this cause an issue? Thin gauge sheets tend to move around when the force of the water hits them.

We typically only cut .187" thk and over on the water-jet.

Please advise if this causes an issue...



SPRINGSIDE INDUSTRIES INC.
Custom Fabricating Services

Regards,
Matthew Challice

Account Manager & Estimating

Springside Industries Inc.
673012 Road 67A
RR#1 Badjeros Ont.
N0C 1A0

Cell: 1-226-755-3484 Fax: 1-519-340-0384
Website: www.springsideindustries.com
Email: matt@springsideindustries.com

Please consider the environment before printing this e-mail

*Unapproved process
was supposed to use water jet.
NOT laser. OK
10/17/2013
NCR 13-3136*

From: Michael Gregoire [<mailto:mgregoire@dartaero.com>]
Sent: Thursday, September 19, 2013 8:46 AM
To: Matthew Challice
Subject: RE: PO20895

Good Morning Matthew,
The last order that was returned to us, does not appear to have been done on the water jet, the score marks and the burn patterns suggest that these parts were done on the laser machine.
Can you explain why the deviation from the drawing occurred?
Regards,
Mike

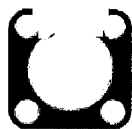
From: Matthew Challice [<mailto:matt@springsideindustries.com>]
Sent: September 16, 2013 3:12 PM
To: Michael Gregoire
Subject: RE: PO20895

Good Afternoon

Just following up to see if you received the last sample part we sent you?

We are fairly slow on the water-jet right now, we can offer you an excellent turn around on the thicker aluminum parts we quoted for you.

Thank you



SPRINGSIDE INDUSTRIES INC.
Custom Fabricating Services

Regards,
Matthew Challice

Account Manager & Estimating

Springside Industries Inc.
673012 Road 67A
RR#1 Badjeros Ont.

NOC 1A0

Cell: 1-226-755-3484 Fax: 1-519-340-0384

Website: www.springsideindustries.com

Email: matt@springsideindustries.com

Please consider the environment before printing this e-mail

From: Michael Gregoire [<mailto:mgregoire@dartaero.com>]

Sent: Tuesday, August 27, 2013 9:09 AM

To: Springside Industries (matt@springsideindustries.com)

Subject: PO20895

Good Morning Matthew,

The 2 samples you sent have been approved, so you can proceed with the balance of the order. We have added a 3rd item to the order as well, D3537-3P with the template will be sent to you today. Once you make the First Article Inspection for that part and we approve it you can send all 3 items back to us.

Regards,

Mike Gregoire

Purchasing

Dart Aerospace

Tel:613-632-3336

Fax:613-632-5246

No virus found in this message.

Checked by AVG - www.avg.com

Version: 2013.0.2890 / Virus Database: 2638/6037 - Release Date: 01/16/13

Internal Virus Database is out of date.

No virus found in this message.

Checked by AVG - www.avg.com

Version: 2013.0.2890 / Virus Database: 2638/6037 - Release Date: 01/16/13

Internal Virus Database is out of date.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO20895**

Purchase Order Date 8/12/2013

PO Print Date 8/27/2013

Page Number 1 of 2

Order From :

SPRINGSIDE INDUSTRIES INC.
673012 ROAD 67A
R.R. # 1 BADJEROS
ONTARIO, NOC 1AO
CANADA

VC-SH001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone cell11-226-755-3484

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

FAXED
(613) 632-1053

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2438F CUT AS PER DWG D2438 REV. C B105681	Clamp	9/6/2013 Yes 9/6/2013		120.00 Each	\$1.39	\$166.80
Line Total:							\$166.80
2	D3537-1P CUT AS PER DWG D3537 REV. C B105680	WEARPAD	9/6/2013 Yes 9/6/2013		100.00 Each	\$2.32	\$232.00
Line Total:							\$232.00
3	D3537-3P CUT AS PER DWG D3537 REV. C B105934	WEARPAD	9/6/2013 Yes 9/6/2013		100.00 Each	\$2.63	\$263.00

Note:

8/27/2013



Packing Slip

Date	S.O. No.
8/14/2013	3232

Name / Address
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont. K6A 1K7

Ship To

[illegible]

Shipper: _____

Trucker: _____

Reciever:

Any claims Of Shortage's & Damages to be made in 10 days or less from receipt of Goods.. Otherwise we will not be held responsible. Thanks !!



MILL TEST CERTIFICATE

SHANXI TAIGANG STAINLESS STEEL CO., LTD

No. 2 JIANCAOPING, TAIYUAN, SHANXI, P. R. CHINA
TEL: +86-351-3013328 FAX: +86-351-3017816
Http://www.tisco.com.cn
E-mail: tgbxg@tisco.com.cn

Certificate No	ABB120708A
Material	304/304L
Surface	2B
Standard	ASTM A240/A240M
Heat Treatment	Solution 1050~1100 Quenching in water

Customer	Contract No.	Date
	AB1207AKB002/T2654	2012/10/11

Product	Melting furnace	Inspectors stamp	Marking
COIL	EAF+AOD K-OBM-S+VOD		Shanxi Taigang Stainless Steel CO., LTD

No.	Heat No.	Coil No.	Batch No.	Quantity	Dimensions (inch)	Edge	Weight (Kg)	PB
6	A2203477	KA20819350110	72084823	1	160A*48"*C	slit	10174	
7	A1203357	FA20851030V20	82082205	1	140A*60"*C	slit	9070	
8	A1203357	FA20851830V30	82082204	1	140A*60"*C	slit	9229	
9	A2203476	KA20817020V10	72088238	1	100A*48"*C	slit	9322	
10	A1203357	FA20850390V20	82091322	1	110A*60"*C	slit	8236	
Total								

Chemical Composition %													
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	N	Mo	Ti	Nb	
A2203477	0.022	0.36	1.61	0.036	0.001	18.1	8.0		0.45				
A1203357	0.026	0.43	1.55	0.035	0.001	18.3	8.0		0.05				
A1203357	0.026	0.43	1.55	0.035	0.001	18.3	8.0		0.05				
A2203476	0.019	0.43	1.54	0.036	0.001	18.1	8.0		0.04				
A1203357	0.026	0.43	1.55	0.035	0.001	18.3	8.0		0.05				

Test No.	Tensile Re MPa	Proof Stress Rp0.2 MPa	Proof Stress Rp1.0 MPa	Elongation			Hardness		
				A80(%)	A(%)	A50(%)	HB	HBS	HV
72084823-T	665	281				53.0		85.0 85.0	
82082205-T	635	282				57.0		83.0 83.5	
82082204-T	635	282				57.0		83.5 83.0	
72088238-T	690	305				52.0		89.0 88.5	
82091322-T	645	293				58.0		84.0 83.0	

Notes:

- The quality management system is in conformity with ISO9001:2008 standard.
- The environmental management system is in conformity with ISO14001:2004 standard.
- No weld repair; Free of mercury.
- Surface and dimensions control: O.K.
- Intergranular corrosion test: NO CRACK.
- We hereby certify that the material described above has been detected and has no radiation contamination.

Place: Taiyuan

Work Inspector:

Page: 2 of 2



May 15 2014